



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D5770-041

Job Sheet 208150



Part No: D5770-041

Job Qty: 2 pcs

Part Name: Attachment Hoop



Part Weight: 0 lbs

Job Created: 3/12/20

Due Date: 3/24/20

Type: Stock

Status: RELEASED DATE Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

Note: URF 20-522 DWG D5770 REV.A IPP REV:A NEW ISSUE 20.01.14 JV VERF:DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 2/12/12 AUTH: SAJ



## Bill of Materials

## Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Mill - 1	2		3/24/20	0.25	0.67	Conventional Mill - 1		1/1 20/3/13
	pcs						Conventional Mill - 2		
110	QC 2	2		3/24/20	0.00	0.00	QC 2 - 1		1/1 20/3/13
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S263547



Part: D5770-041

Job No: 208150

Serial No/Batch: S263547

Revision: REV.A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.  
1270 Aberdeen St  
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Canada  
Tel: (613) 632-5200  
Fax: (613) 632-5246  
Email: info@dartaero.com  
Web: www.dartaero.com

Date:

Plex 3/12/20 6:55 AM Dart.Renwick.Jennifer

3/12/2020

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

120 QC 8	2 pcs	3/24/20	0.00 0.00	QC 2 - 66	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 89	
				QC 2 - 76	
				QC 2 - 86	
				QC 8 - 12	m/20/03/14
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Large Fab - Welded Assy- 1	2 pcs	3/24/20	0.00 1.00	Large Fab - 1 - B4B	Sh
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
140 QC 9	2 pcs	3/24/20	0.00 0.00	QC 9 - 10	DAS 43 9-89
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
150 QC 5	2 pcs	3/24/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	

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				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	DAS
				QC 5 - 49	43
				QC 5 - 51	2-22
				QC 5 - 56	
				QC 5 - 68	
				QC 5 - 8	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160 Packaging 3-1 - Stock -	2	3/24/20	0.00 0.00	Packaging 3 - 1 - B4B	
B4B	pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	DAS
				Packaging 3 - 20 - B4B	43
				Packaging 3 - 21 - B4B	2-22
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	2	3/24/20	0.00 0.00	QC 21 - SA - 21	MAR 19 2020
	pcs			QC 21 - SA - 70	QAS
				QC 21 - SA - 83	QAS

Part Op 100 - 1-Start with DS770-5 hoop as stock. 2-Machine as per drawing see sheet 3 detail C. 3-Debur

Descriptions: 119 - QC2- Inspect parts off machine FAV/FAIB

120 - QC8- Inspect parts - second check

130 - 1-Attach two DS770-7 lugs to 11.000" spacing jig DT NA CP using 3/8-24 bolt. Align lugs to slots in hoop prepared in step 1. Centre as per view A-A sheet 1. 2-Weld as per sheet 1. 139072 rod Batch: 139072

140 - QC9- Inspect visual per QSI004- Fusion Welds

150 - QC5- Inspect part completeness to step on W/O

160 - Identify as per dwg & Stock Location: \_\_\_\_\_. See note 6.  
170 - QC21- Final Inspection - Work Order Release

**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
D5770-5	Hoop	2 pcs (1 ea)	100-Conventional Mill - 1	S261807
D5770-7	Lug	4 pcs (2 ea)	130-Large Fab - Welded Assy-1	S259494

**Job Allocations**

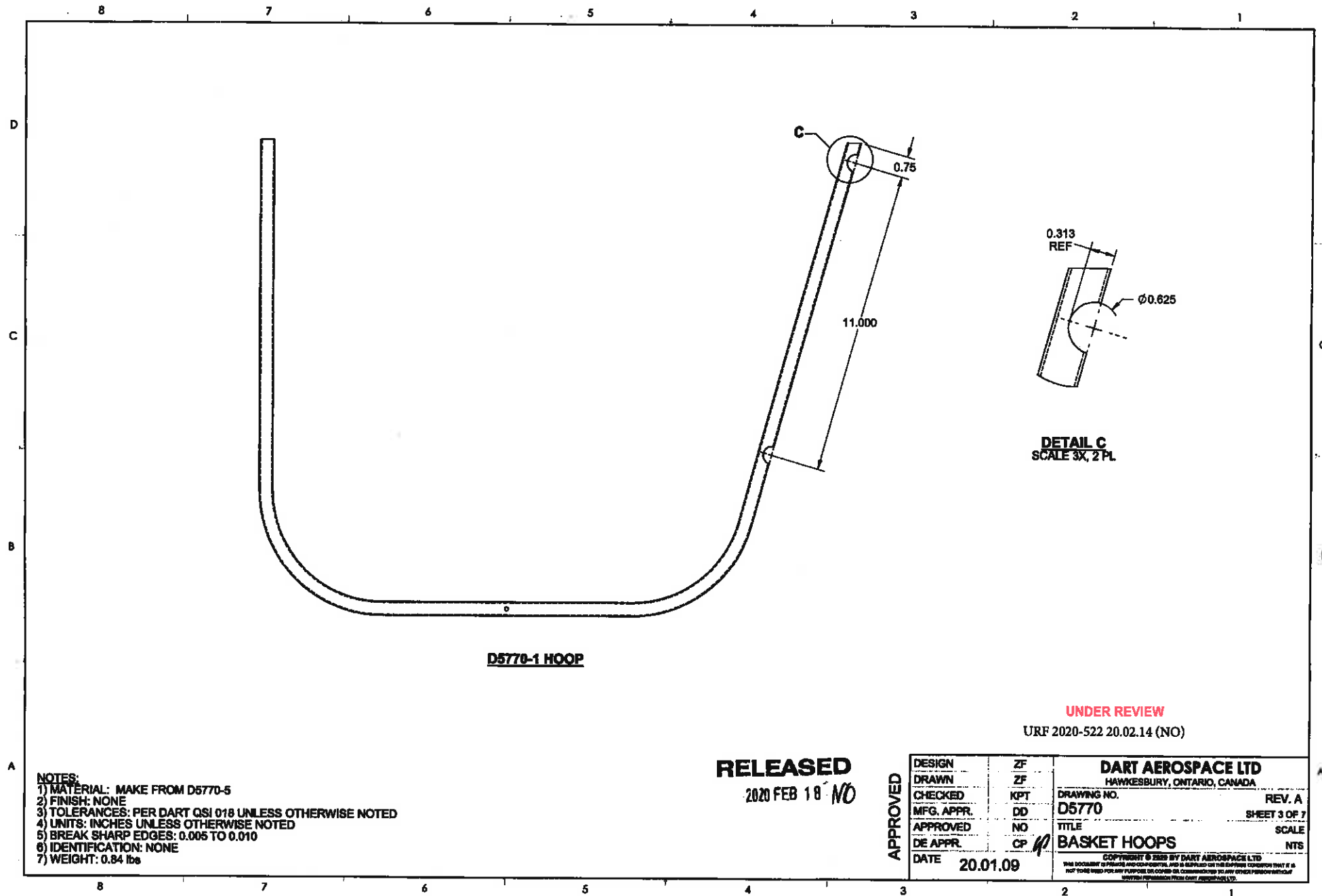
Operation	Component Part	Required	Inventory	Allocated
100-Conventional Mill - 1	D5770-5	2	10	0
130-Large Fab - Welded Assy-1	D5770-7	4	12	0

**Part Specifications**

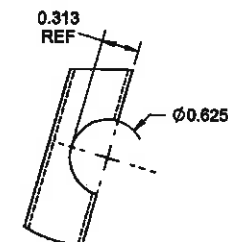
Specifications could not be found.

Plex 3/12/20 8:55 AM Dart.Renwick.Jennifer





**D5770-1 HOOP**



**DETAIL C**  
SCALE 3X, 2 PL

**UNDER REVIEW**

URF 2020-522 20.02.14 (NO)

**RELEASED**  
2020 FEB 18 NO

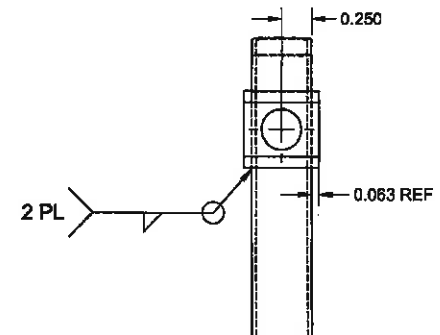
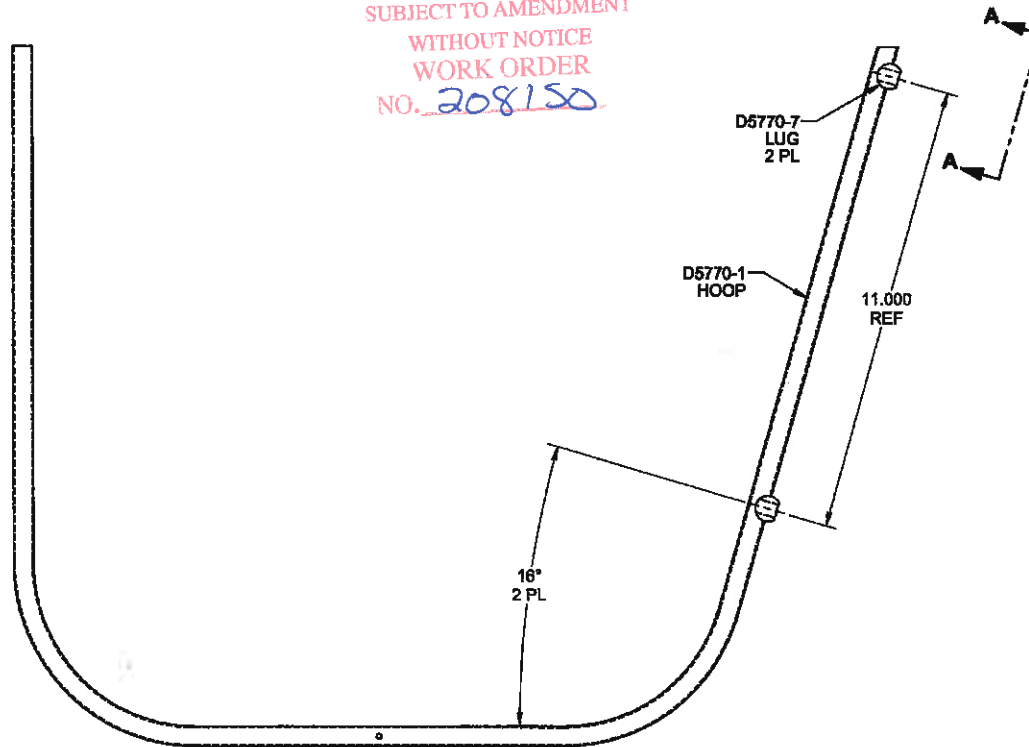
- NOTES:**
- 1) MATERIAL: MAKE FROM D5770-5
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.84 lbs

**APPROVED**

DESIGN	ZF	<b>DART AEROSPACE LTD</b>	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	<b>D5770</b>	SHEET 3 OF 7
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	<b>BASKET HOOPS</b>	NTS
DATE	20.01.09	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE BASIS OF THE INFORMATION CONTAINED HEREIN IS NOT TO BE USED FOR ANY PURPOSES OR FOR ANY OTHER REASON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

QTY -041	P/N	DESCRIPTION
X	D5770-041	ATTACHMENT HOOP
1.	D5770-1	HOOP
2	D5770-7	LUG

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 208150



VIEW A-A  
SCALE 3X, 2 PL

**D5770-041 ATTACHMENT HOOP**  
(DERIVED FROM AERO DESIGN P/N 76422-01)

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
  - 7) WEIGHT: 0.91 lbs
  - 8) WELD PER DART QSI 004

RELEASED

2020 FEB 18 NO  
ECN 2020-521

APPROVED

A NEW ISSUE		ZF	20.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.09		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5770

TITLE

BASKET HOOPS

REV. A

SHEET 1 OF 7

SCALE

NTS

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
<b>Root Cause</b>  Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Presservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/>		<b>FAULT CATEGORY</b>  <div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> <div> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>			
Other/Details:					